

Date Thursday, 16/08/2007 10:31:01 AM
 User Linda Lacelle

Process Sheet

Customer	CU-DAR001 Dart Helicopters Services		Drawing Name	ARM	
Job Number	34001		Part Number	D28443	
Estimate Number	11048		Drawing Number	D2844 REV A	
P.C. Number	N/A		Project Number	N/A	
This Issue	16/08/2007	S.O. No.	N/A	Drawing Revision	A
Prsh Rev.	NC		Material	N/A	
First Issue	N/A		Due Date	03/09/2007	
Previous Run	33198		Qty:	20	
Written By			Um:	Each	
Checked & Approved By					
Comment	Est: B 00.11.01 Removed P/O for Powder Coat - in house processEC				

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	M304TRO500W035	304 RD Tube .500 x .035W	
		Comment: Qty.: 1.8533 f(s)/Unit Total: 37.0650 f(s) 304 RD Tube .500 x .035W M304TRO500W035 Punch 304/316 Seamless tubing with 2B finish, 1/2" OD x .035 Wall 19.82" long (Hole ctr. to hole ctr.) using Jig DT 8012 Batch M105354	FF 07-08-31 20
2.0	BRAKE NC	NC BRAKE	 Comment: BAND SAW Form per Dwg D2844 using brake and bending Jig DT 8238-B Deburr
3.0	QC5	INSPECT WORK TO CURRENT STEP	 Comment: INSPECT WORK TO CURRENT STEP
4.0	POWDER COATING	POWDER COATING	 Comment: POWDER COATING Powder Coat White Gloss (Ref: 4.3.5.2) as per QSI 005 4.3
5.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION	 Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: Date: 07/09/14
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07/09/13	# 2.0	one part was lost between Job# 20 to 30 RL Human error and carelessness	J QX042	tell employees not to miss place parts and Always Count the pieces before starting Jobs And when job is complete	F.F. SAN MK. Hill MUL 07/09/13	Er 09/09/13	/ QSMRZ	Er 07/09/13
				- Part was found in C.N.C Dept.				

NOTE: Date & initial all entries

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Seq. #: Machine Or Operation:

Description :

6.0 QC6 DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

Ensure parts are still as per dwg D2844

7.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

1/9/14 SG (20)

8.0 QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

1/9/14 SG (20)
D07109/14

Job Completion



U 87.09.14

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

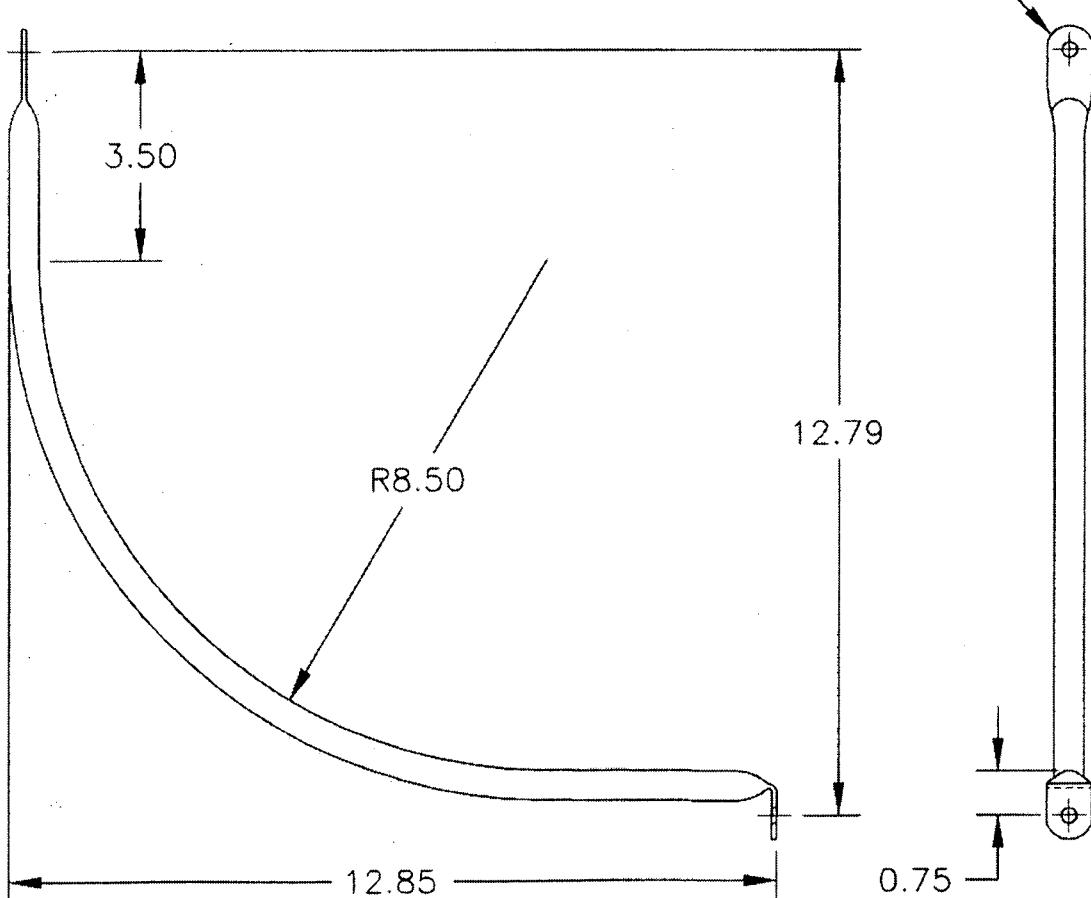


OACOPY
DRAFT

DESIGN <i>KE</i>	DRAWN BY <i>KE</i>	DART AEROSPACE USA, INC. FAIRCHILD INTERNATIONAL AIRPORT, WA
CHECKED <i>PAH</i>	APPROVED <i>S</i>	DRAWING NO. D2844
DATE 98.10.14		TITLE ARM
A	98.10.14	SCALE 1:3 NEW ISSUE

RELEASED
98.10.11 KE

PUNCH ENDS PER SPEC CONTROL DRAWING D2727



D2844-1

W/O 3400

MATERIAL: AISI 304/316 SS TUBE, Ø0.50 x 0.035 WALL
ENSURE TUBE IS SEAMLESS

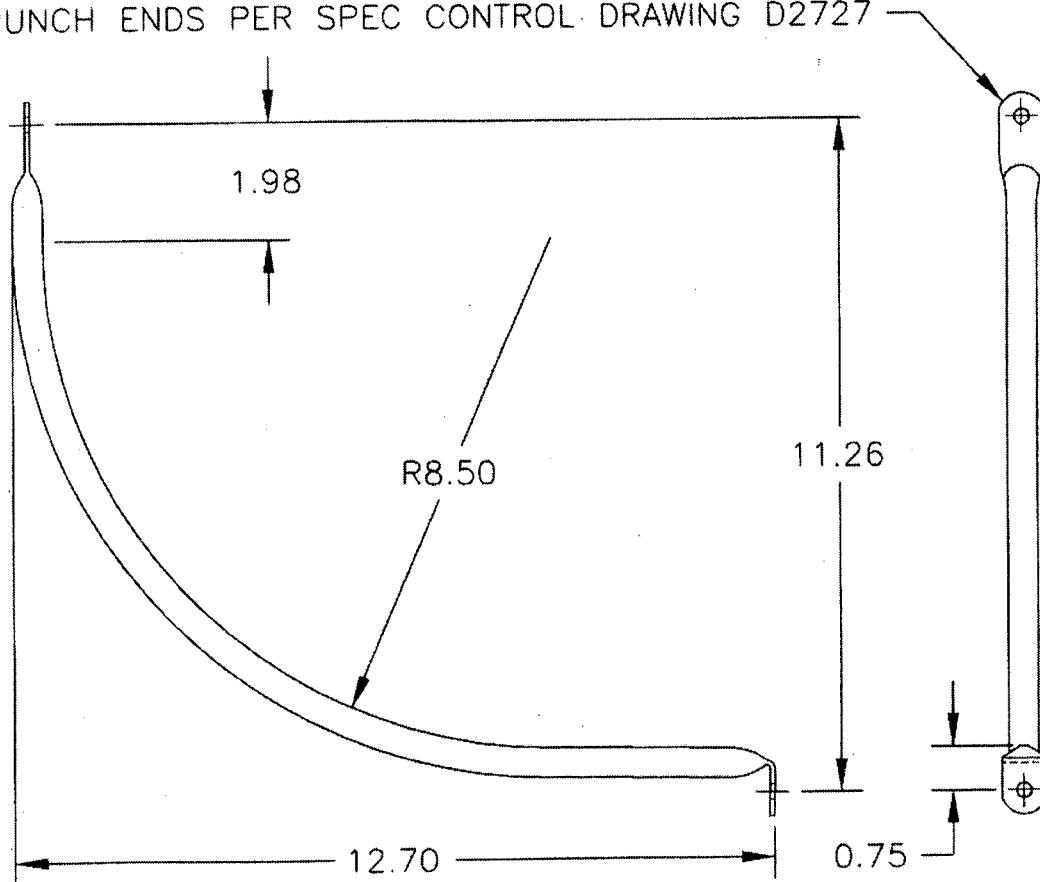
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3

DART

DESIGN KE	DRAWN BY KE	DART AEROSPACE USA, INC. FAIRCHILD INTERNATIONAL AIRPORT, WA	
CHECKED DAH	APPROVED <i>[Signature]</i>	DRAWING NO. D2844	REV. A SHEET 2 OF 2
DATE 98.10.14		TITLE ARM	SCALE 1:3

RELEASED
19.11.11 KE

PUNCH ENDS PER SPEC CONTROL DRAWING D2727



D2844-3

MATERIAL: AISI 304/316 SS TUBE, $\phi 0.50 \times 0.035$ WALL
ENSURE TUBE IS SEAMLESS

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3

